

**Work Order ID 67358**

Wednesday, March 16, 2011 12:03:10 PM

Page 1

Item ID: D3766-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Front Rail, RH

Start Date: 3/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start




QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3766	Rev B								
100		0.00							
	Small Fab								
Small Fab	<b>Memo</b>	0.00							
Small Fab	1-cut tube to lenght as per dwg D3766□2-drill holes thru to finish size as per dwg D3766 using DT9413,,drill holes labelled #2□3- deburr								
									⇒ m-d 11/03/17
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	<b>Memo</b>	0.00							
Quality Control									
120		0.00							
	Chemical Conversion Coat per QS1005 4.1								
HandFinish	<b>Memo</b>	0.00							
Hand Finishing									

10X

⇒ m-d 11/03/17

8 uloz 11/3

10

10 BR 11-3-21.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Revision ID:

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Start Date: 3/16/2011 Start Qty: 10.00

Required Date: 3/23/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10.0 3/16/2011

140

Identify as per dwg &amp; Stock Location: 254

0.00



Packaging

Memo

0.00

Packaging

4/13/22 (1)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22

C24103/22

# Dart Aerospace Ltd

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# Picklist Print

Wednesday, March 16, 2011 12:03:16 PM

Page 1  
1

Work Order ID: 67358



Parent Item: D3766-2



Parent Item Name: Front Rail, RH

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC  
IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188 		Purchased	No			100	f	50.7374	2.7927	29.39684			
6061T6 RD TUBE 1.00 X .188W													

*Mit 11/03/17*

Location	Loc Qty	Loc Code
MAT016	50.737418	
114089	17.275108	
2x 115868 ✓	9.46231	
8x 116720 ✓	24	

*5.8793*  
*23.5174*

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**NOTE:** Date & initial all entries

2 SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 61358  
2/11-03-14

**D3766-1 FRONT RAIL, LH**

**D3766-2 FRONT RAIL, RH**

**D3766-3 REAR RAIL**

- NOTES:  
 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: D3766-1, 1.55 lbs  
 D3766-2, 1.55 lbs  
 D3766-3, 1.55 lbs

RELEASED  
 08.07.10

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	<b>D3766</b>	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	<b>RAIL</b>	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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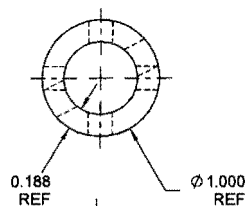
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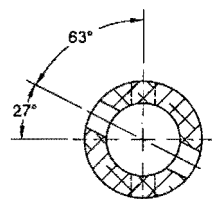
**NOTE:** Date & initial all entries



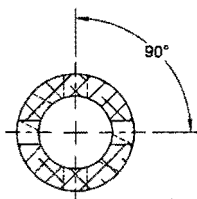
W/O 47358



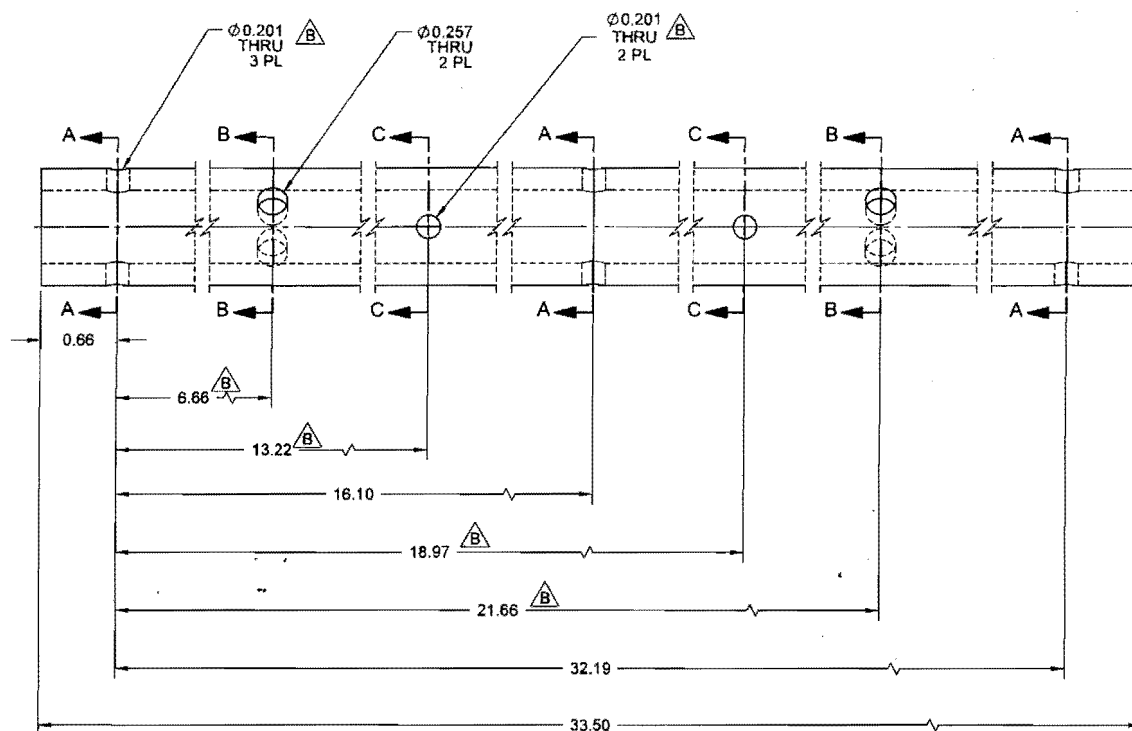
**SECTION A-A**



**SECTION B-B**



**SECTION C-C**



**D3766-1 FRONT RAIL, LH**

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08-07-10

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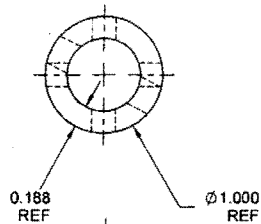
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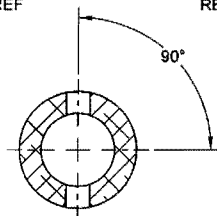
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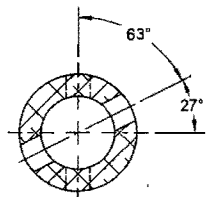
w/o 47358



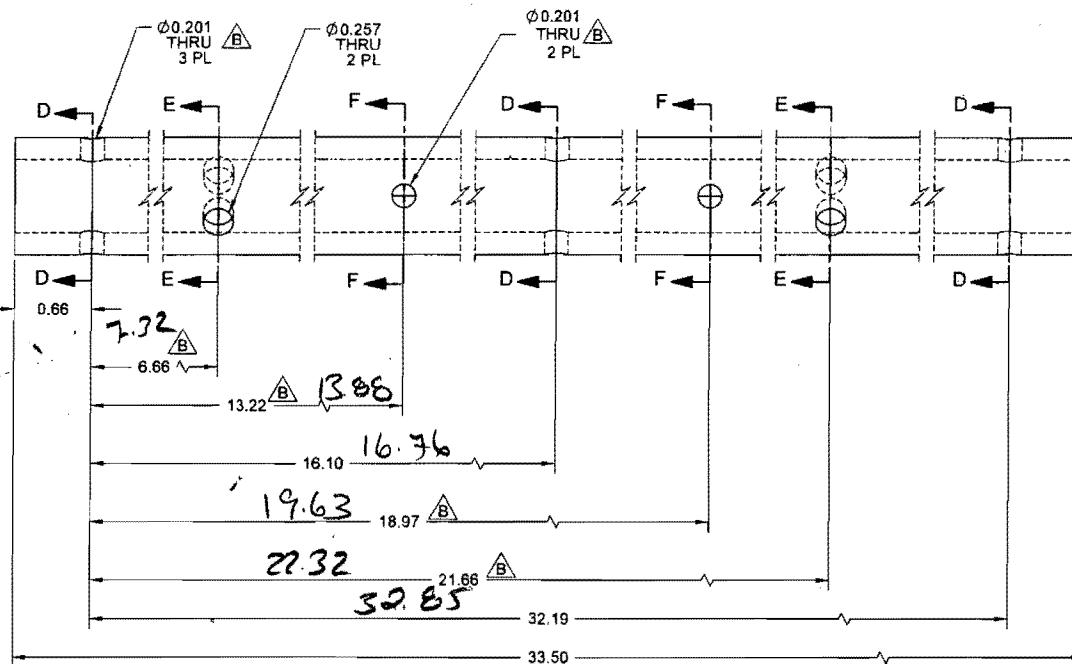
**SECTION D-D**



**SECTION E-E**



**SECTION F-F**



**D3766-2 FRONT RAIL, RH**

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CHECKED	HS	DRAWING NO. <b>D3766</b>	REV. B
MFG. APPR.		TITLE <b>RAIL</b>	SHEET 3 OF 4
APPROVED		SCALE	NTS
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**Dart Aerospace Ltd**

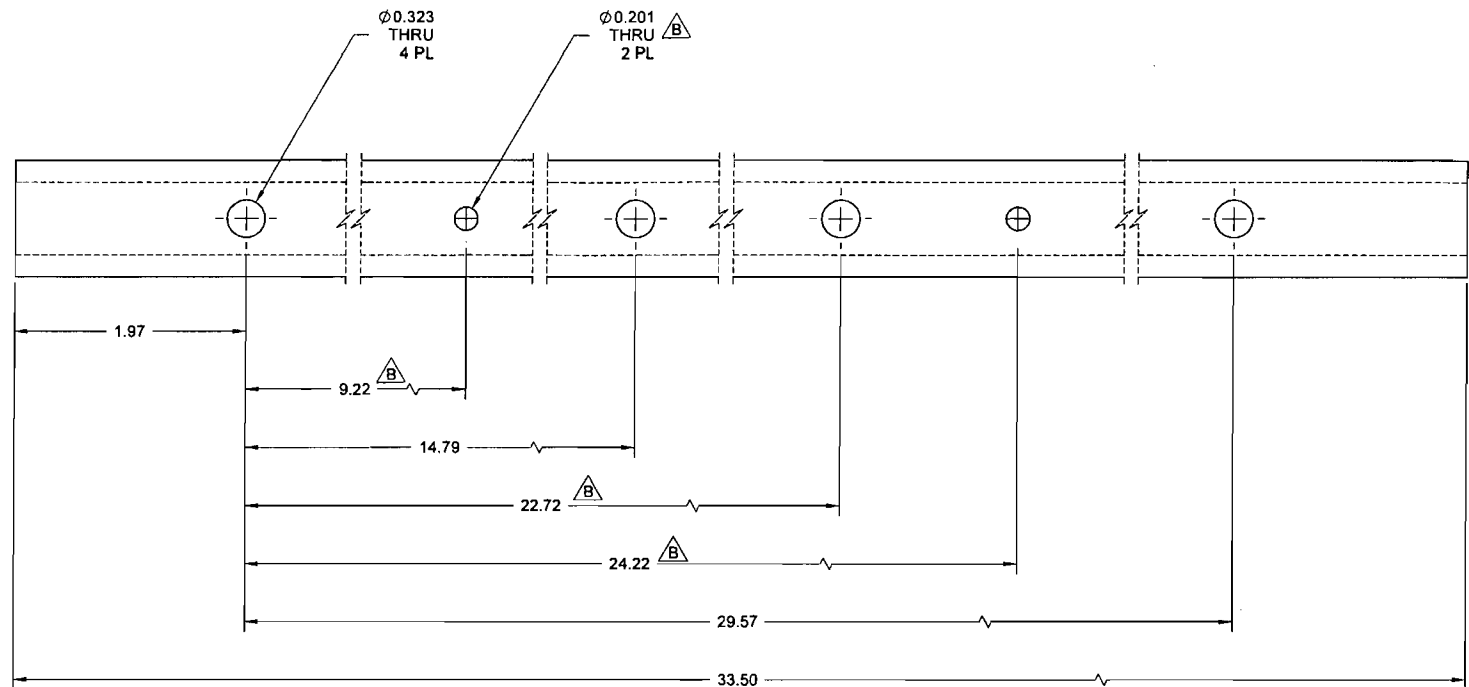
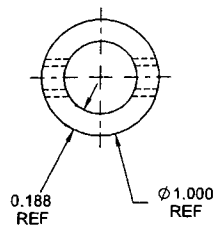
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ULO 47358



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CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.		<b>D3766</b>	SHEET 4 OF 4
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DE APPR.		<b>RAIL</b>	NTS
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